

DART AEROSPACE LTD	Work Order:	22427
Description: Custom W/O to correct c'bore deep	Part Number:	D3369-041
	Keyed:	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3369 Rev. A1 page 1 & 2		
Ref: N/A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	05.02.15	\$
2	SALES	Remove D206-739-011 Dual Disabling Kits from finished inventory. D3369-041 current production. Qty Part Number Description Batch D206-739-011 Dual Disabling Kit 622425B D3369-041 Battery Lock 622284	J	05.02.15	104
3	GA	Open box and remove D3369-041 Battery Lock Assembly. Disassemble Cam mechanism on D3373-1 Lock assembly.	J	05.02.15	104
4	GA	Re-work by c'bore Ø1.25" bore as per Dwg. D3369. D3369-041 current production and the painted.	BE	05.02.15	104
5	GA	Deburr.	J	05.02.17	104
6	QC5	Inspect work up to per step 5. Return current production to the original W/O.	JA	05.02.17	104
7	WS	Assemble D3369-041 painted Cam mechanism as per Dwg D3369, ensuring nut is secure. Weld D3369-3 lock shaft with thick square washer. Using the key, ensure disconnect/lock works properly, and the key can be removed in the lock/open position.	J	05.02.17	800
8	QC5	Inspect work to Step 5	PD	05.02.17	8
9	ST	Repack D206-739-011. Ensure batch and key number matches with the box.	U	05.02.21	104
10	SALES	Return to finished inventory	CL	05/02/23	7
11	AC	Cost / part: 150.08	CL	05/02/23	7
12	DC	Close W/O Inspect Level 21	5UR	05.02.25	7
			KA	05.03.02	7

(Note: Attach a copy of Custom W/O to each of the W/O's listed in Step 2 above)

Rev	Date	Change	Revised By	Approved
A	05.02.15	New Issue	KJ/RF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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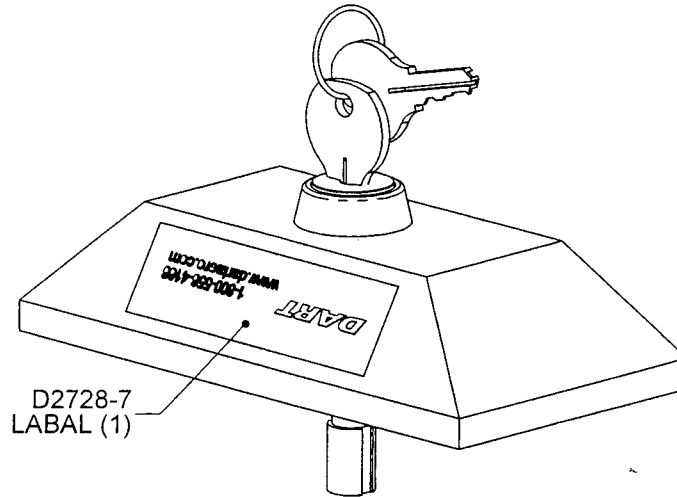
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



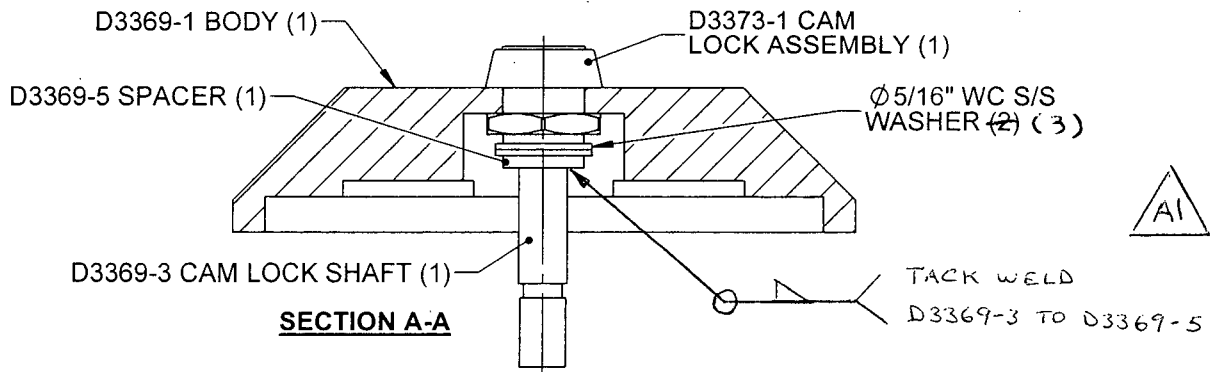
DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED MS	DRAWING NO. D3369	REV. A SHEET 1 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:1.5
A	04.12.16	NEW ISSUE	



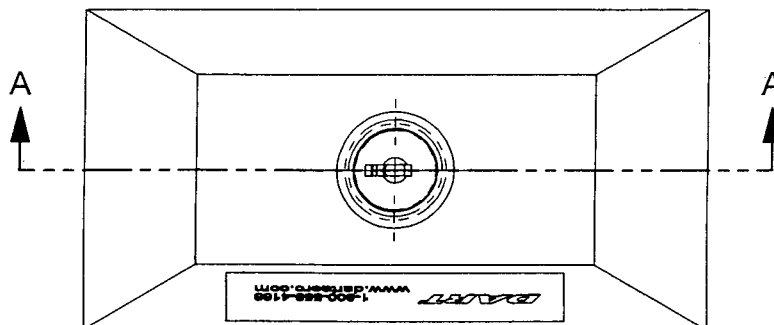
D2728-7
LABAL (1)

BATTERY LOCK SHOWN LOCKED WITH KEY

RELEASED
05/02/11



SECTION A-A



D3369-041 BATTERY LOCK ASSEMBLY

NOTES:

1) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22427

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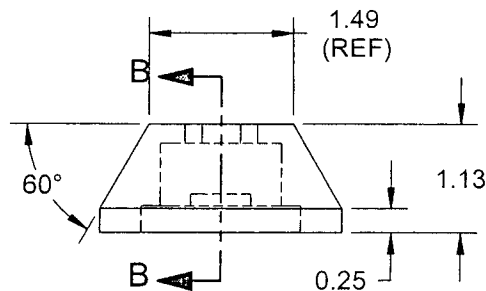
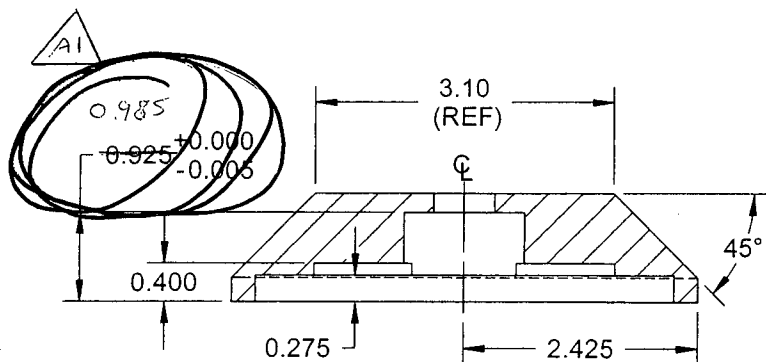
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ADD TACK WELD
0.865 WAS 0.925

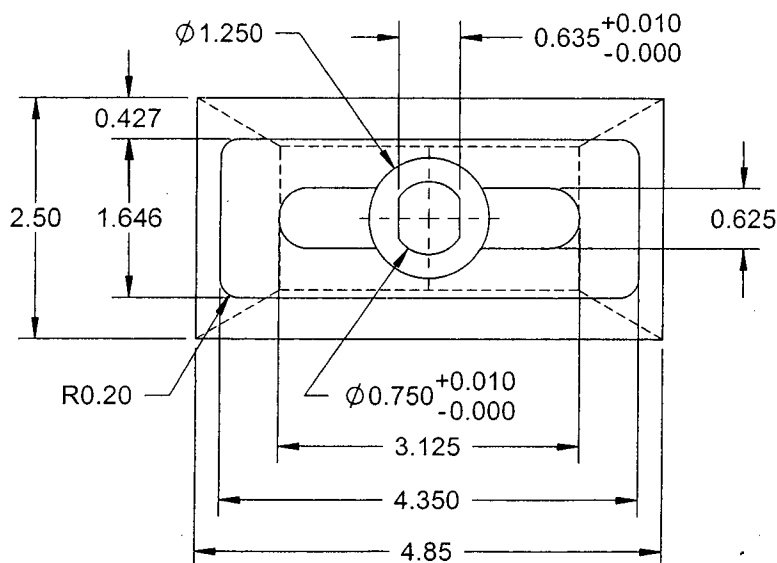
A1 11/07 05.02.11



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 2 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:2



SECTION B-B



RELEASED
[Signature]

05/02/11

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
NO. 22427

D3369-1 BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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